

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006532**Date Inspected:** 15-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #10 South and North Tower Shop

North tower lift#2:- Caltrans QA Inspector observed five ZPMC welders in process FCAW root pass on interior diaphragms of skin plate A. The interior diaphragms located at the elevation 53m to 80.75m. The minimum preheat and maximum interpass temperature requirements for FCAW root pass welds are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay #11 East and West Tower Shop

East Tower Lift#1:- Caltrans QA Inspector observed six welders performed FCAW process on PJP welds for corner diagonal stiffener that connected skin plate C to D and B to C. The PJP welding located along at elevation 9m to 47.6m diaphragm. The grinding and FCAW welding process are removing and repair the PJP welds that have been rejected by VT inspection. Base on Caltrans observation, no discrepancies were noted.

East Tower Lift#2:- Caltrans QA Inspector observed three welders performed grinding and FCAW repair process on rat holes of diaphragm that connected skin plate C. The rat holes are located at elevation 9m to 47.6m diaphragm section. The grinding and FCAW welding process are removing and repair the PJP welds that have

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been rejected by VT inspection. Base on Caltrans observation, no discrepancies were noted.

East Tower Lift#3:- Caltrans QA Inspector observed six workers and two welders installed and SMAW tack welding process on four stiffeners to skin plate D of east tower lift #3. The four stiffeners has been re-welded prior installation due to the exceed length has been found by Caltrans QA Inspector few day ago. The four stiffeners number is ESD1-FDSA3-2B/C-56 A/B, 54 A/B, 52 A/B and 50 A/B. Base on Caltrans observation, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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